

# ASAP

**Dart Aerospace Ltd.**

Date: Wednesday, 25/10/2006 8:27:14 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SCUFF PLATE
<b>Job Number</b> : 29020	
<b>Estimate Number</b> : 11952	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206555003
<b>This Issue</b> : 25/10/2006	<b>Drawing Number</b> : D206-555 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 29020	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 08/11/2006
<b>Checked &amp; Approved By</b> : _____	<b>Qty:</b> 10 <b>Um:</b> Each
<b>Comment</b> : est rev C 99.06.29 returned to electro polish DM Est Rev:D Now on Waterjet 06-10-25 JLM	

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555  
using DT 8316-3

SB 07/01/10 10

2.0	<del>M304G25GA</del> m304526GA (C) 304/316 .020" Sheet
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**Comment:** Qty.: 0.4148 sf(s)/Unit Total: 4.1475 sf(s)

304/316 .020" Sheet 25GA

Batch: 11102376

ML 07/01/04

(10)

3.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D206-555

Dwg Rev: C

Prog Rev: C

ML 07/01/04

(10)

2-Deburr if necessary

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ML 07/01/04

(10)

Date: Wednesday, 25/10/2006 8:27:14 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 29020

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

~~2007~~ 07/01/04 (10)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Finish form on bench forming Jig DT 8317-3

SP 07/01/10 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/10 (10)

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services  
Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.  
Issue P/O: 2844  
Possible supplier: TQF Technologies

07/01/10 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

07/01/19 (10)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-10 (10)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Remove tooling tabs and deburr

N/A

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

Date: Wednesday, 25/10/2006 8:27:14 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 29020

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C20710119 10

14.0

QC21

FINAL INSPECTION/W/O RELEASE



15

Comment: FINAL INSPECTION/W/O RELEASE

0710119

Job Completion



C20710119

Date: Monday, 10/16/2006 2:02:20 PM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SCUFF PLATE
<b>Job Number</b> : 29020	
<b>Estimate Number</b> : 11952	
<b>P.O. Number</b> :	<b>Part Number</b> : D206555003
<b>This Issue</b> : 10/16/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D206-555 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 26229	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/8/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : est rev C 99.06.29 returned to electro polish DM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
-----	----	------------



**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_  
E-mail or Ship DXF file to vendor  
Laser cut flat pattern as per Dwg  
Possible supplier: Ind. Laser  
Material release note is required.

*295 SF  
MS045256A*

2.0	D206555003F	scuff plate flat
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
scuff plate flat

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Recieve & Inspect for Transit Damage  
Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Form parts on hydraulic press as per Dwg. D206-555  
using DT 8316-3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/16/2006 2:02:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 29020

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Finish form on bench forming Jig DT 8317-3

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: \_\_\_\_\_

Possible supplier: TQF Technologies

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/16/2006 2:02:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 29020

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

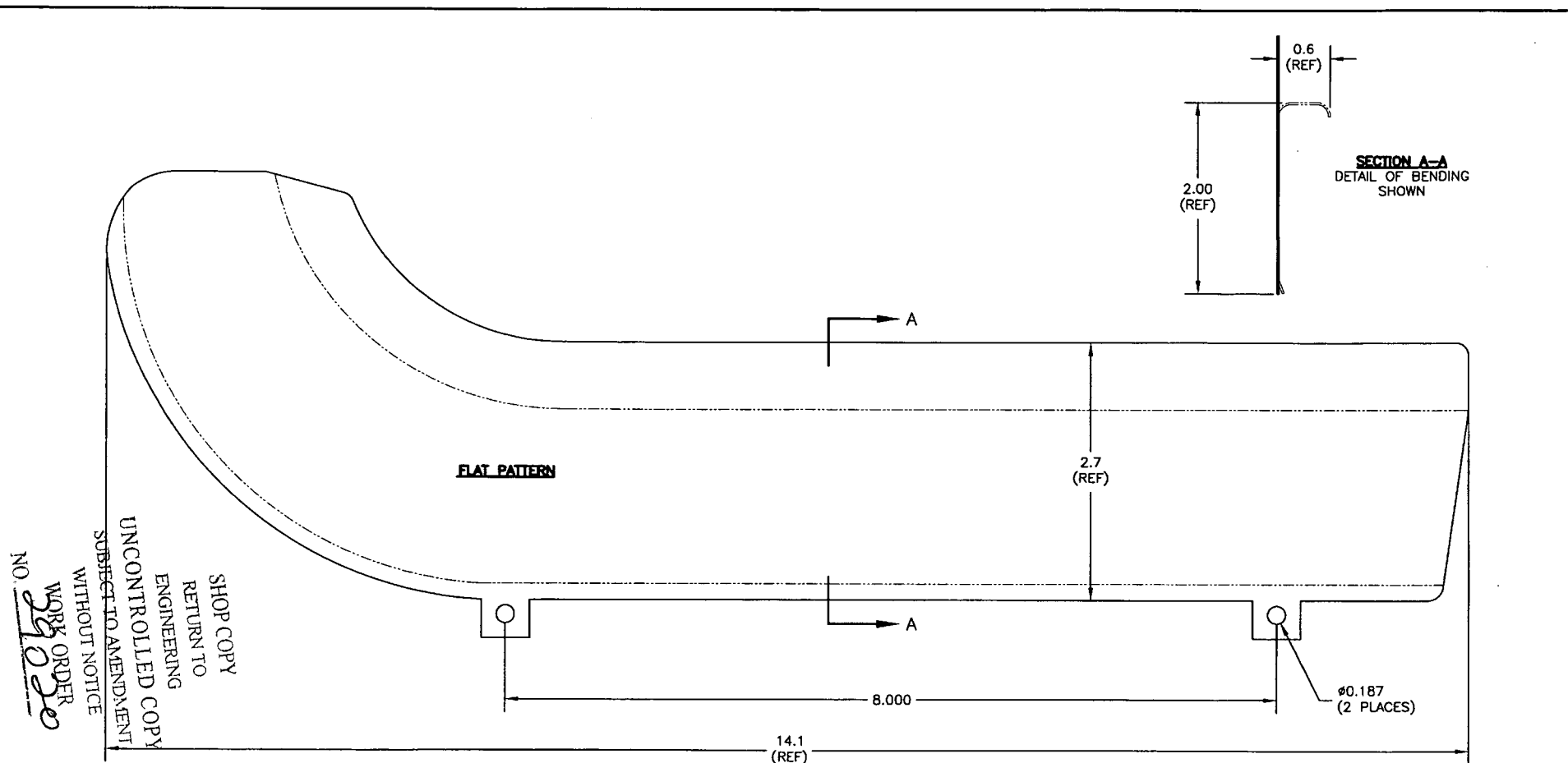
DESIGN JB	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY  
RETURN TO  
**RELEASED**  
06.09.01  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29020

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**D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)**  
**D206-555-002 (BEND OPPOSITE)**

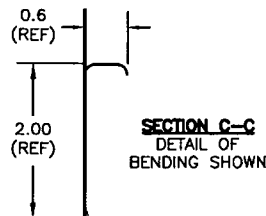
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**

06.09.19

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



DETAIL B  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

16.000 (REF)

2.7  
(REF)

FLAT PATTERN

8.000

19.0  
(REF)

8.000

Ø0.187  
(3 PLACES)

RELEASED

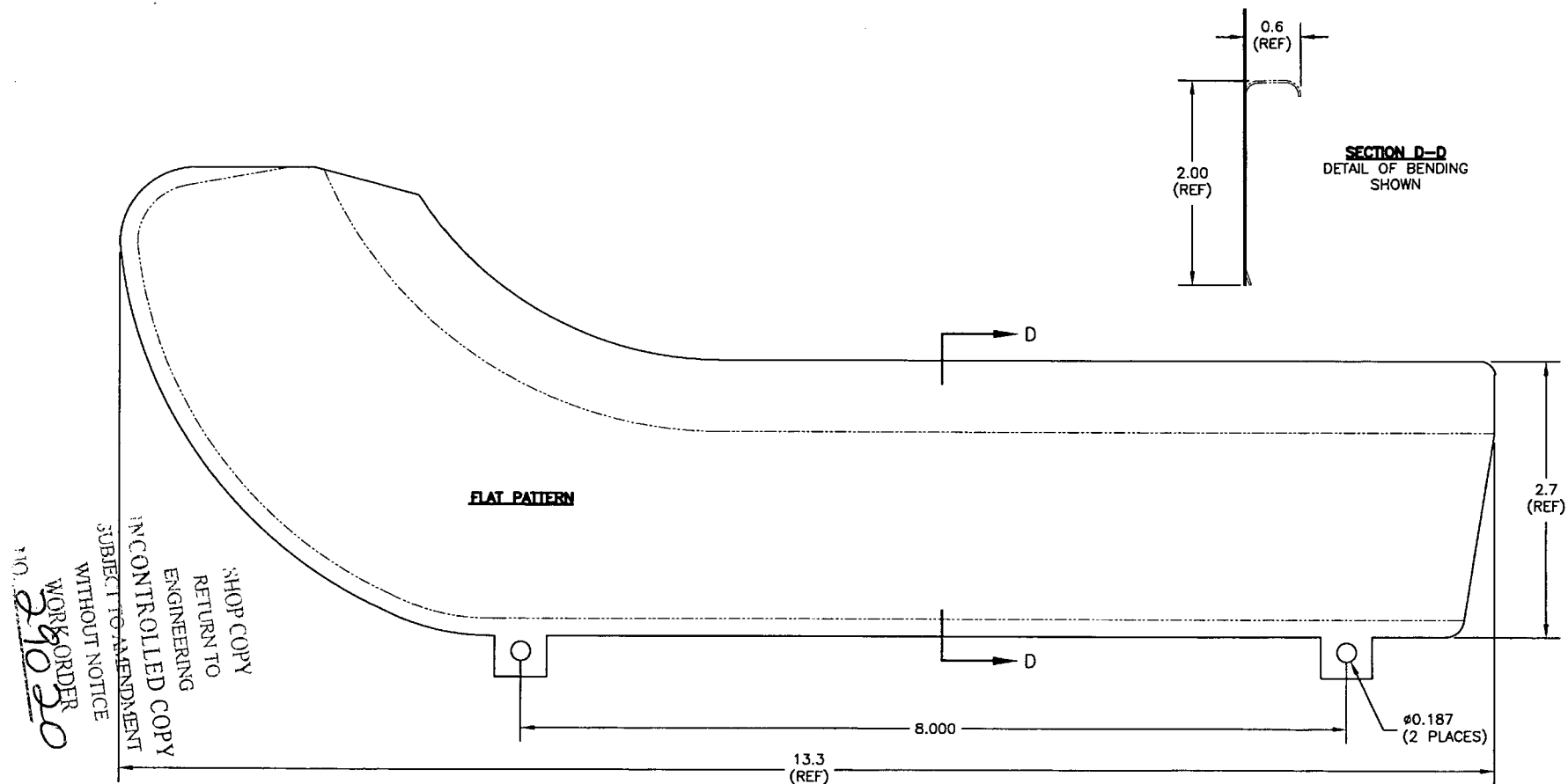
06.09.19-#

D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)  
D206-555-004 (BEND OPPOSITE)

#### NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 3 OF 7 SCALE 2:3



**D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)**  
**D206-555-006 (BEND OPPOSITE)**

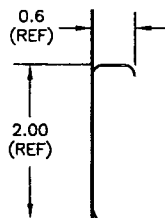
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

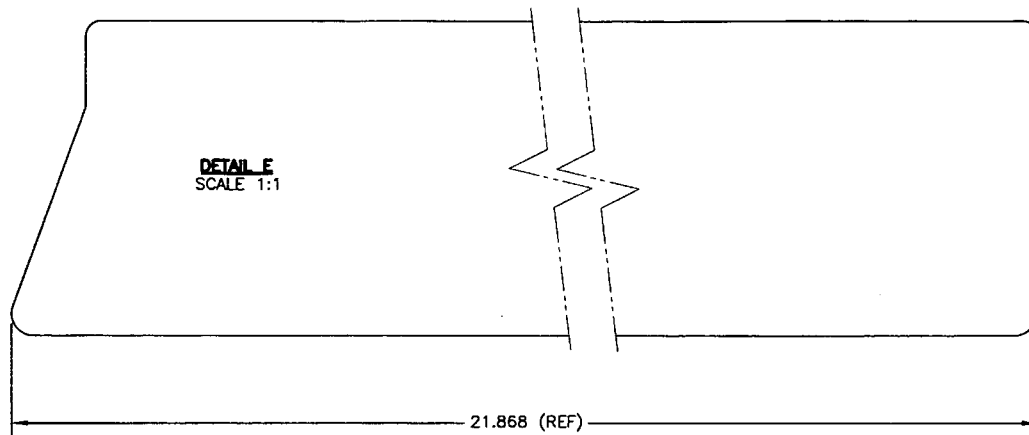
RELEASED

06-09-19

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



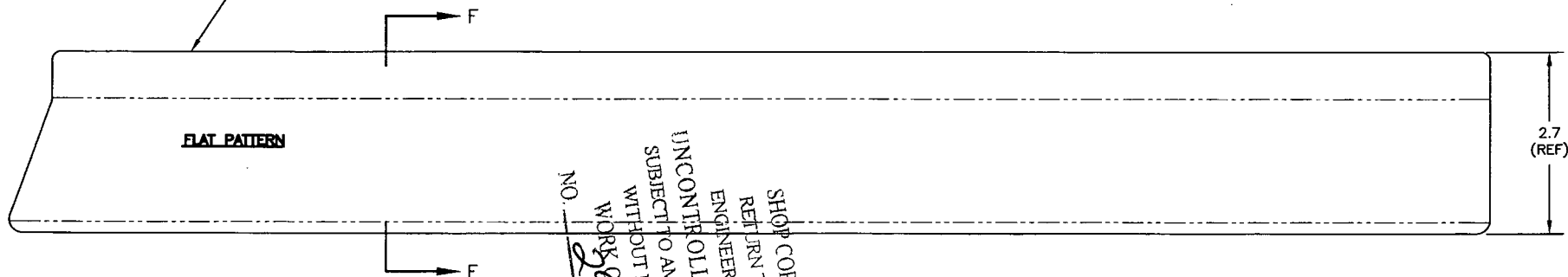
**SECTION F-F**  
DETAIL OF  
BENDING SHOWN



**DETAIL E**  
SCALE 1:1

REFER TO DETAIL E  
FOR 1:1 SCALE

21.868 (REF)



**FLAT PATTERN**

2.7  
(REF)

NO. 21020  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

RELEASED

06.09.19

**D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)**

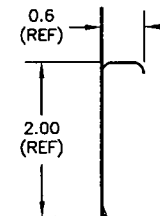
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WAINESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED H	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 5 OF 7 SCALE 2:3

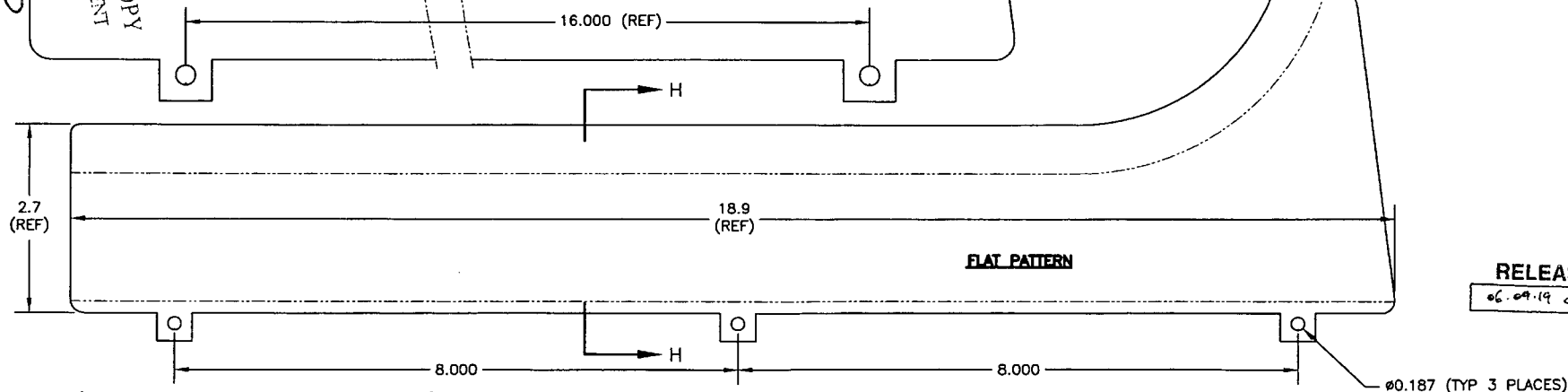
NO. 29030  
WORK ORDER  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

DETAIL G  
SCALE 1:1



SECTION H-H  
DETAIL OF  
BENDING SHOWN

REFER TO DETAIL G  
FOR 1:1 SCALE



RELEASED

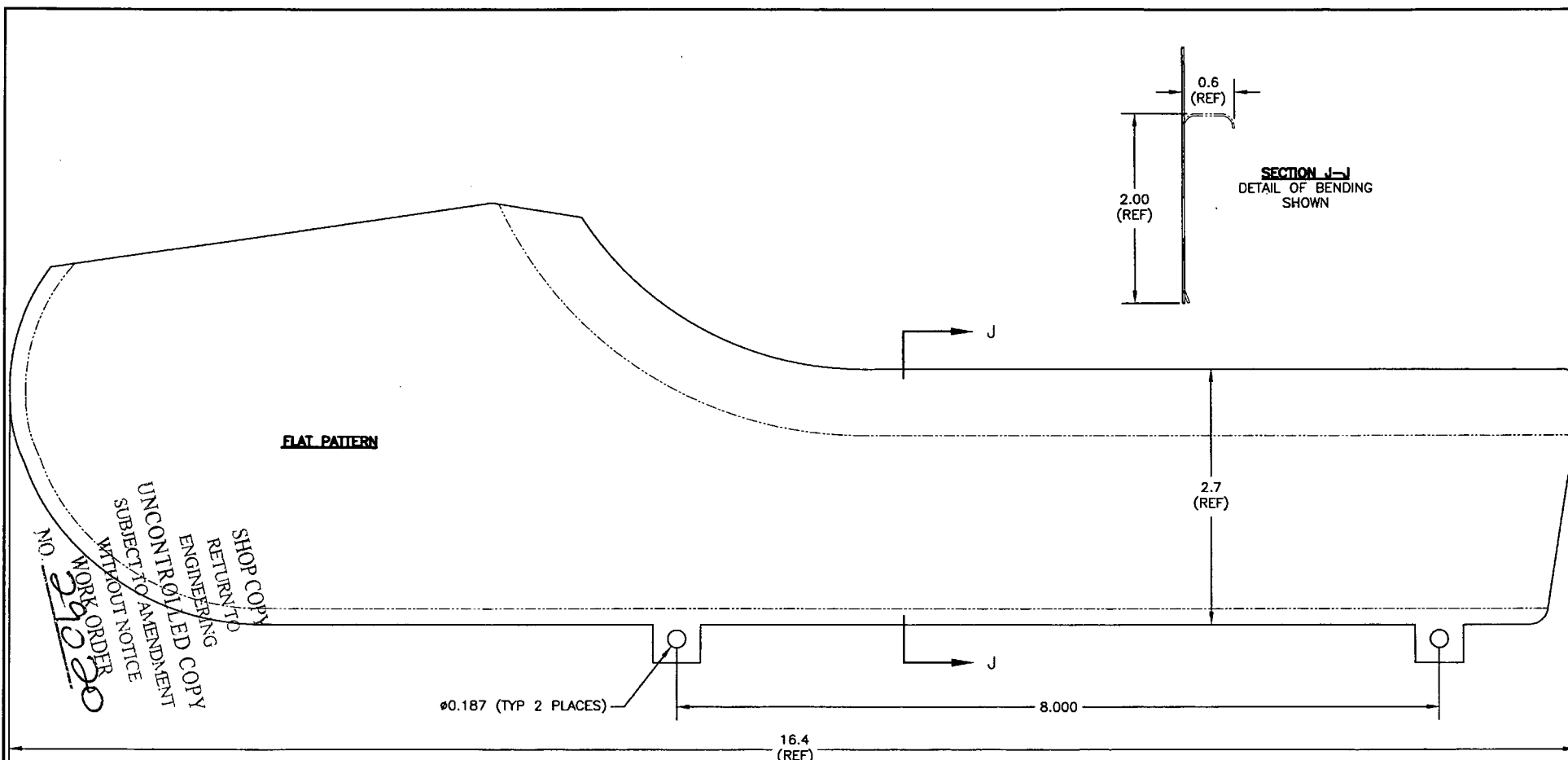
06.09.19

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WARRICKSLEY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)  
D206-555-012 (BEND OPPOSITE)

#### NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.01

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 7 OF 7 SCALE 1:1







## Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: January 16, 2007

1270 Aberdeen St

Hawkesbury, Ontario

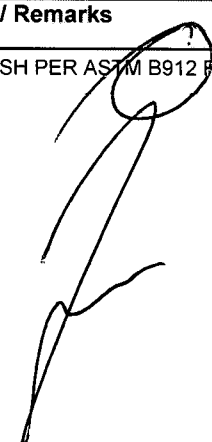
No. de certificat  
Certification No.

K6A 1K7

tel.: (613) 632-9577

fax: (613) 632-1053

**C111759**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
122494	10	<b>NO. DE COM./P.O.#</b> 2844 D206-555-003 REF#B2902	ELECTROPOLISH PER ASTM B912 REV.02 

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

Signé pour et au nom de TQF Technologies Inc.  
Signed for and on behalf of TQF Technologies Inc.




Raj Thakoordeen